

stretchers kids



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D2345

Job Sheet 196563



Part No: D2345

Job Qty: 12 pcs

Part Name: Lock Channel



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/14/19

Job Tracking No:

Due Date: 7/19/19

Created By: Lorin Baltac

Type: SOLD

Description:

Note: DWG REV A IPPRevB 99.05.31 Re-format DM IPP Rev:C Now on Waterjet 06-10-26 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		7/19/19	0.17	0.87	Waterjet - Flow		JRB 6/20/19
120	QC 8	12 pcs		7/19/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - 2 - B4B	12 pcs		7/19/19	0.00	0.84	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		

X 1 1/2 hrs
Fred

DAS
JUN 20 2019 40
9-89

DAS
71
9-89

140	Small Fab - Brake NC - B4B	12 pcs	7/19/19	0.25 0.80	Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - Brake - 1 - B4B	DAS 71 9-89
150	QC 5	12 pcs	7/19/19	0.00 0.00	Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	19-6-25
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DAS 40 9-89
160	Packaging 3-1 - Stock - B4B	12 pcs	7/19/19	0.00 0.00	Packaging 3 - 1 - B4B	JUN 26 2019
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	

200
17
08-0

200
17
08-0



				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	12 pcs	7/19/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	JUL 05 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D2345

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Small Fab) Deburr if necessary.

140 - (Form as per dwg) Form as per Dwg D2345 using DT8241 Remove tooling tab and buff flush

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____) LOCATION : GA

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.6336 sf (.0528 ea)	100-Waterjet - Flow - 1	5105488 5105488

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	1	333	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lock Channel	2.800Inches $\pm$ 0.010	2.810 2.790	2.800	2.800
2	Lock Channel	2.520Inches $\pm$ 0.010	2.530 2.510		2.520
3	Lock Channel	0.094Inches + 0.004 - 0.001	0.098 0.093	0.096	Diameter
4	Lock Channel	0.478Inches $\pm$ 0.010	0.488 0.468	0.480	
5	Lock Channel	1.256Inches + 0.005 - 0.001	1.261 1.255	1.259	
6	Lock Channel	0.197Inches $\pm$ 0.010	0.207 0.187	0.199	Diameter
7	Lock Channel	2.750Inches $\pm$ 0.010	2.760 2.740	2.749	
8	Lock Channel	3.000Inches $\pm$ 0.010	3.010 2.990	2.999	
9	Lock Channel	0.050Inches $\pm$ 0.010	0.060 0.040	0.048	

Plex 6/14/19 2:29 PM Dart.Baltac.Lorin



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Container No: S192123



Part: D2345

Job No: 196563

Serial No/Batch: S192123

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/20/19